

Date: Friday, 10/20/2006 11:05:47 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MIRROR BRACKET
Job Number :	29082A02		
Estimate Number :	10144		
P.O. Number :		Part Number :	D20136
This Issue :	10/20/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2013 REV C
First Issue :	1/1	Project Number :	N/A
Previous Run :	24160A02	Drawing Revision :	C
Written By :		Material :	
Checked & Approved By :		Due Date :	10/27/2006
Comment :	Est Rev:A New Issue 05-11-01 JLM	Qty:	10 5 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total: 9.0825 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: M102502

FF 06-11-07 10

2.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Punch as per template D2013-T5 and Dwg D2013

FF 06-11-07 10

2-Flatten ends of D2013-6 tube as per Dwg D2013 using DT8545

FF 06-11-07 10

3-Bend tube as per Dwg D2013 using Jig DT8201 Identify as D2013-6.

FF 06-11-08 10

4-Deburr as required

FF 06-11-07 10

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

D 06/11/09 10

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

D 06/11/10

Job Completion



C Loe 11/10

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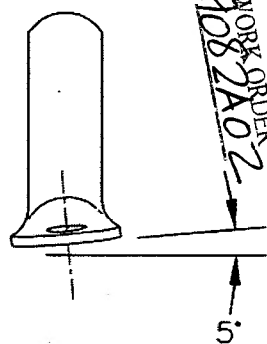
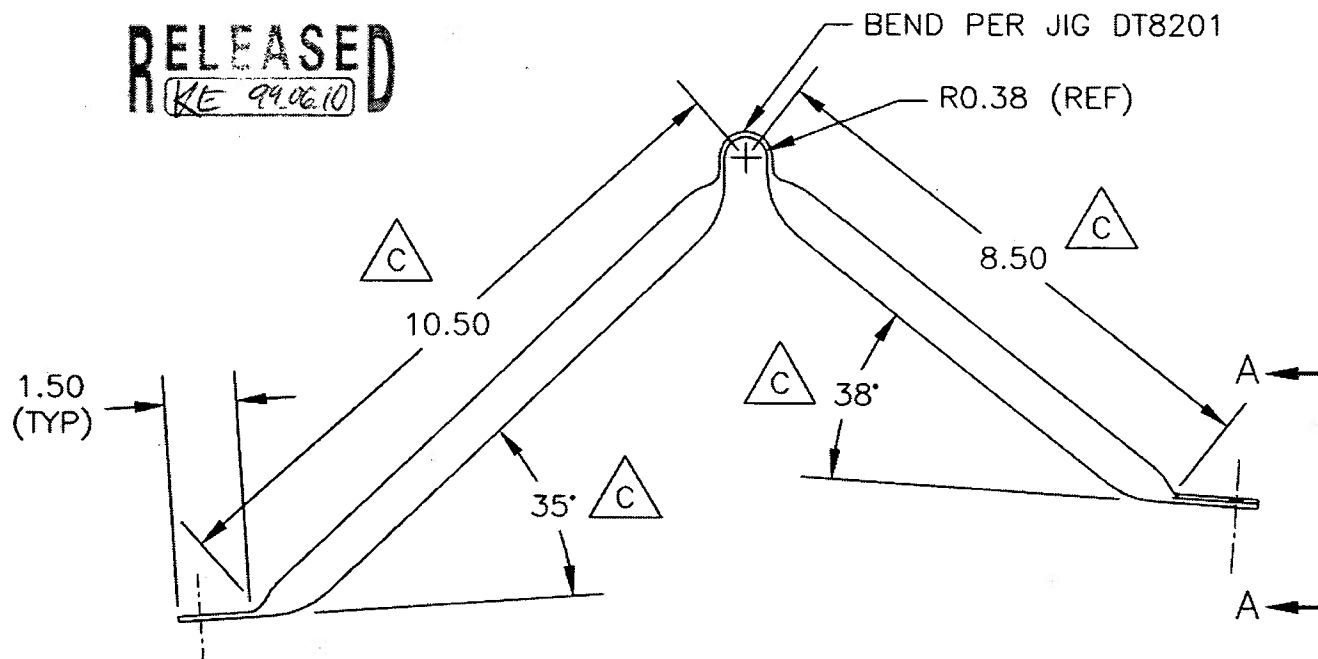
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 06/11/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
KE 99.06.10



VIEW A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
4082402

D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)

DRILL $\varnothing 0.257$ (TYP)

0.400 (TYP)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

DART



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	JD	REV. C
DATE	99.06.07	DRAWING NO.	D2013	SHEET 1 OF 3
		TITLE	MIRROR BRACKET	SCALE
				NTS
	A	90.10.22	NEW ISSUE	
	B	94.06.15	REDRAWN	
	C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

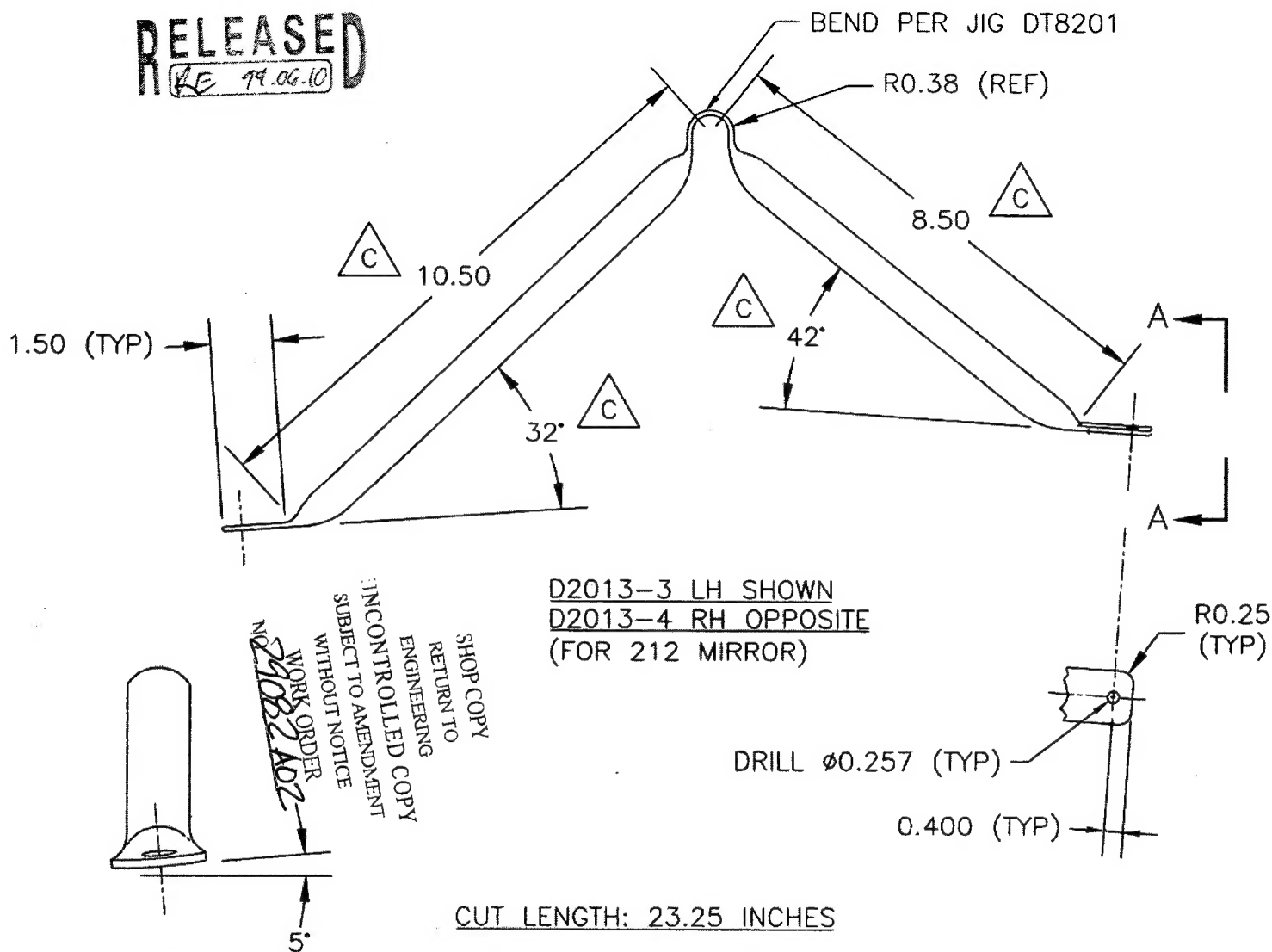
NOTE: Date & initial all entries

RELEASED
KE 79.06.10

DART



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 2 OF 3
		SCALE	NTS	



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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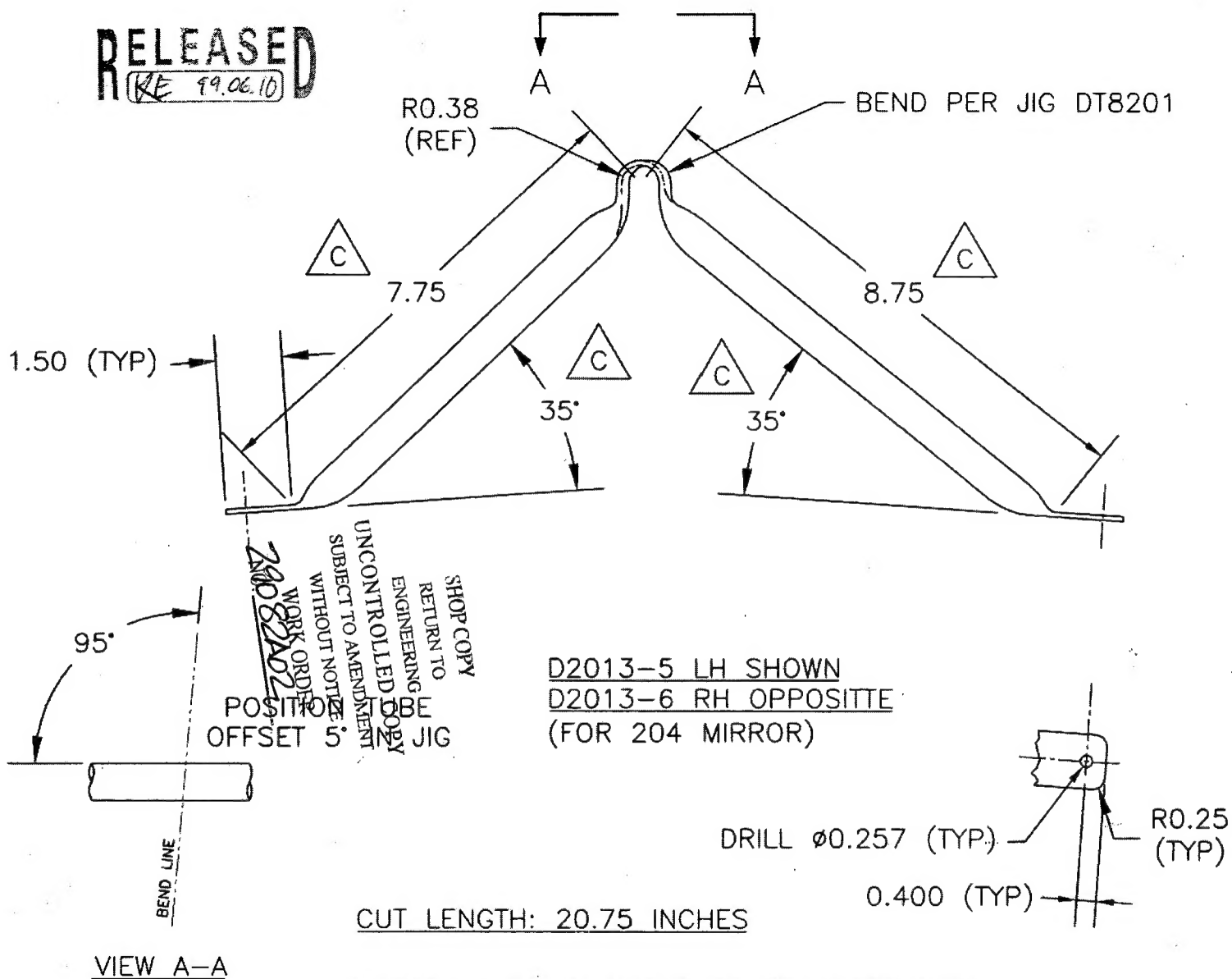
NOTE: Date & initial all entries

RELEASED
(KE 99.06.10)

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	RM	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED	DRAWING NO. D2013
DATE 99.06.07		SHEET 3 OF 3
	TITLE MIRROR BRACKET	SCALE NTS



VIEW A-A

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries